

Work Order ID 80862

Thursday, March 01, 2012 3:54:49 PM

80862

Page 1

Item ID: D206-642-151

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Skidtube

Start Date: 3/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date: 2-03-1

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

100

DC

DOCUMENT CONTROL

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

m120164

3BE 12/03/05

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

SAD 12-03-05

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

SAD 12-03-06

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

SAD 12-03-07

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

SAD 12-03-07

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

S, 7/63/07

Quality Control

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									
160		0.00							
160									
Skidtubes	Skidtubes	0.00							
Skidtubes	Memo								
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1	0	BE 12/03/08
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180

Skidtubes

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 12-03-08 Time: 3:00Finish Date: 12-03-08 Time: 8:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 m/20813Sikaflex expire date: 2012-08-13

①	0	SAD 12-03-08
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1 0 8E12/23/09

W/O:		WORK ORDER CHANGES					
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Start Date: 3/1/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/9/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M120104

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

3 BE 12/23/09

DP 12-3-9

DP 12-3-10

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

210HandFinish
Hand Finishing

HandFinishing

Memo

Install D2680-041 Nut Plate as per Dwg D3804

0.00

0.00

DP

12-3-10

215

215QC
Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

AS

12-03-12

220

220QC
Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

S26312

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230		0.00							
QC	Memo								
Quality Control									
240	Pressure Wash per QSI005 4.3	0.00							
240		0.00							
HandFinish	Memo								
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250		0.00							
Powdercoat	Memo								
Powder Coating	START TIME: 9600 OVEN TEMPERATURE: 320°F FINISH TIME: 9630								

m/20222

IXCM-12/03/13

1 & (2P) 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

1 BR 12-3-14.1 BR 12-3-14.

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280		0.00							
280	HandFinishing					1		BR 12.3.14.	
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 199999 Sikaflex expire date: 12-8. 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: 120125. R4.								
290	QC3- Inspect Part Finish	0.00							
290									
QC	Memo	0.00							8/12/03/15
Quality Control									

8/12/03/15

1 BR 12-3-14.

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300	QC5- Inspect part completeness to step on W/O	0.00							
300									
QC	Memo	0.00							
Quality Control									
310		0.00							
310	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-151								
	Location: _____								
	PPP Rev: <u>PPP Rev 3</u>								
320	QC21- Final Inspection - Work Order Release	0.00							
320									
QC	Memo	0.00							
Quality Control									

5/12/15

C12/3/19

MLJ 12/03/19

MF
12-03-19

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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	30.0000	1	1			
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D2620

Skidtube, 206 Skidtube

**

CF 12-3-5

Location

Loc Qty

Loc Code

LG

30

77996

1

77999

10

78000

5

79542

1

79543

2

79544

8

79545

3

D2647		Manufactured	No			110	Each	63.0000	1	1			
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D2647

Cap

**

BE 12/3/5

Location

Loc Qty

Loc Code

LG002

63

75482

63

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

7,334.000

52

**

12-3-8

CR3212-4-04

Cherry Rivet

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

7166

119075

7166

D2654-1

Manufactured

No

180

Each

17.0000

1

**

SAD 12-03-08

D2654-1

Web

Location

Loc Qty

Loc Code

LG

17

79540

5

79541

10

80054

2

380055

121.0000

2

**

SAD 12-03-07

D3286-1

Manufactured

No

180

Each

D3286-1

Doubler

Location

Loc Qty

Loc Code

LG002

217

74872

6

78014

93

ST046

-96

76772

22

Thursday, March 01, 2012 3:54:54 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,831.000

19

19

**

BE 12/03/09

D2649

Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

1374

77574

2

79502

403

79503

399

79504

309

79565

261

19

LG001

457

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

330

D3286-3

Manufactured No

200

Each

125.0000

2

2

**

BE 12/03/09

D3286-3

Spacer

Location

Loc Qty

Loc Code

LG

15

78015

15

LG001

110

74117

1

79557

109

2

Thursday, March 01, 2012 3:54:54 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 4

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210 Each

171.0000 1 1

**

D2680-041

Nut Plate

LocationLoc QtyLoc Code

ST013

116

78016

116

ST019

55

76790

55

CR3212-4-03

Purchased No

210 Each

1,512.000 2 2

**

CR3212-4-03

Cherry Rivet

LocationLoc QtyLoc Code

FP002

522

114859

522

ST331

990

110139

2

119017

988

AN960JD416

NAS1149D0463J Purchased No

210 Each

24.0000 1 1

**

AN960JD416

Washer

LocationLoc QtyLoc Code

ST351

24

116289

24

CCR264SS3-3

Purchased No

210 Each

767.0000 2 2

**

CCR264SS3-3

Cherry Rivet

LocationLoc QtyLoc Code

ST331

767

113973

2

117849

129

119017

636

Thursday, March 01, 2012 3:54:54 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

212.0000

1

1

MS27039-4-06

Screw

**

BL 12-3-14.

Location

Loc Qty

Loc Code

ST292

212

119075 ✓

212

D2651-1

Manufactured

No

270

Each

749.0000

6

6

D2651-1

Plug

**

BL 12-3-14.

Location

Loc Qty

Loc Code

FP001

884

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584 ✓

245

79234

278

FP-A

-135

77559

1

78124

164

D2651-3

Manufactured

No

270

Each

2,065.000

6

6

D2651-3

O-Ring

**

BL 12-3-14.

Location

Loc Qty

Loc Code

FP001

137

61962

12

73828

125

FP-A

1928

78126 ✓

1928

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

129.0000

14

14

D3873-1

Bushing

**

BL 12-3-14.

Location

Loc Qty

Loc Code

ST067

79561.

129

64760

1

68247

4

73829

19

73830

2

79560.

103

14.

D2646

Manufactured No

280

Each

60.0000

1

1

D2646

Aft Cap

**

BL 12-3-14.

Location

Loc Qty

Loc Code

FP002

79500

60

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

44

1

D3805-041

Manufactured No

280

Each

6.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

BL 12-3-14.

Location

Loc Qty

Loc Code

FP001

78002.

1

76779

1

FP002

5

78002

5

1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,259.000

2

2

MS27039-1-08

Screw

**

BL 123-14-

Location

Loc Qty

Loc Code

ST291

1259

117423

81

119075 ✓

172

119109

6

120308

1000

2.

MS21042L3

Purchased

No

280

Each

3,758.000

7

7

MS21042L3

Nut

**

BL 123-14.

Location

Loc Qty

Loc Code

ST300

3758

117441

16

117885

32

118451

5

118927

3

119017 ✓

3505

119075

197

7

D3805-045

Manufactured

No

280

Each

12.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

BL 123-14.

Location

Loc Qty

Loc Code

FP001

12

73817

1

74896

1

78010

10

1

AN960JD10L

NAS1149D03321 ✓

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

2

BL 123-14.

Thursday, March 01, 2012 3:54:54 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Thursday, March 01, 2012 3:54:54 PM

Work Order ID: 80862

80862

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 3/1/2012

Required Date: 3/9/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each 846.0000 7 7

AN3-37A

**

BR 12-3-14

Bolt

Location

Loc Qty

Loc Code

ST353

846

117619

4

119086 ✓

842

7.

NAS1149D0363J Purchased No

280 Each 2,337.000 7 7

NAS1149D0363.J

**

BR 12-3-14

Washer

Location

Loc Qty

Loc Code

ST298

2337

117601

61

118077

1

118612

18

119537

309

120142 ✓

330

7.

120308

618

120644

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

100-80862 MCT
12/03/02

RELEASED
49-03-03
PC ECN 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 1 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

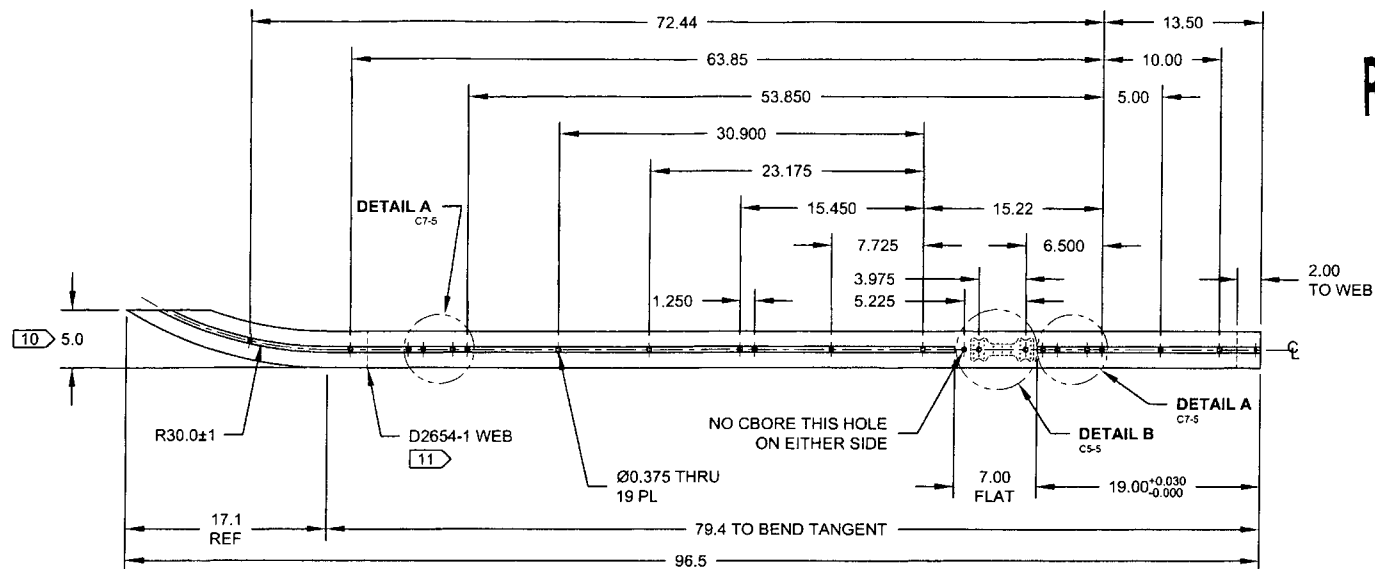
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

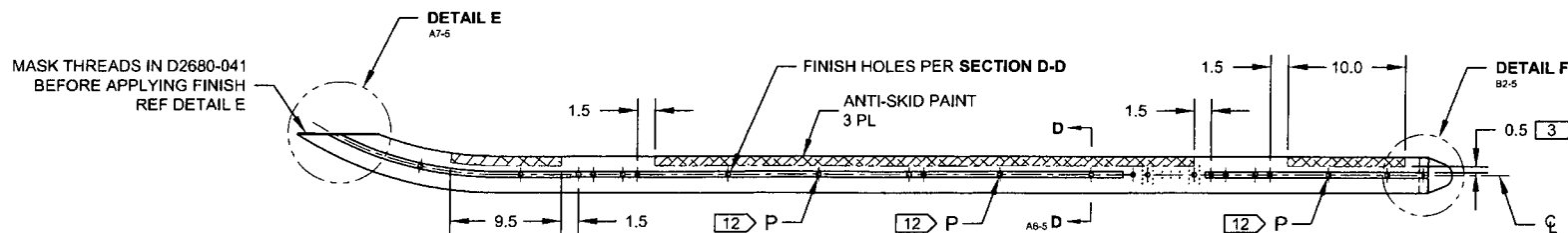
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	91	DART AEROSPACE USA, INC	
CHECKED	92	PORT HADLOCK, WA	
DRAWN	93	DRAWING NO.	REV. A
MFG. APPR.	94	D3804	SHEET 2 OF 5
APPROVED	95	TITLE	SCALE
DE APPR.	96	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80862



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

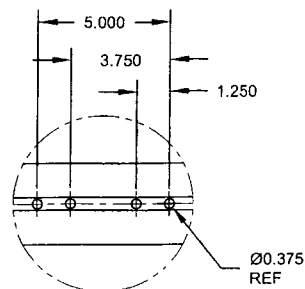
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

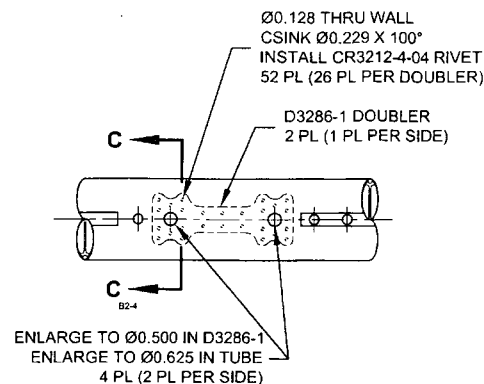
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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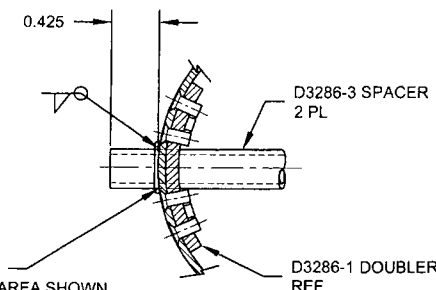
RELEASED
09.05.07



DETAIL A
SCALE NONE
D6-2
C2-2
D6-3
C2-3



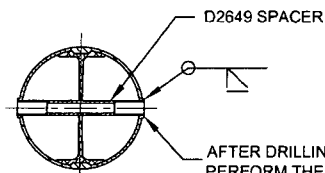
DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

800602

SECTION C-C
PARTIAL SECTION
SCALE NONE
C6-4



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-2
A4-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO. D3804	REV. A
MFG. APPR.	97	SHEET 4 OF 5	
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

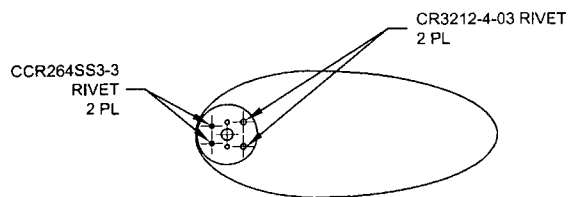
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

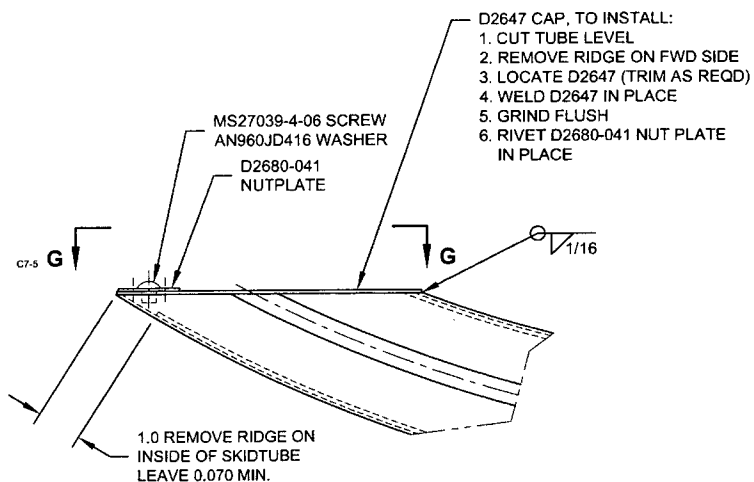
NOTE: Date & initial all entries

RELEASED
09 09 03 03

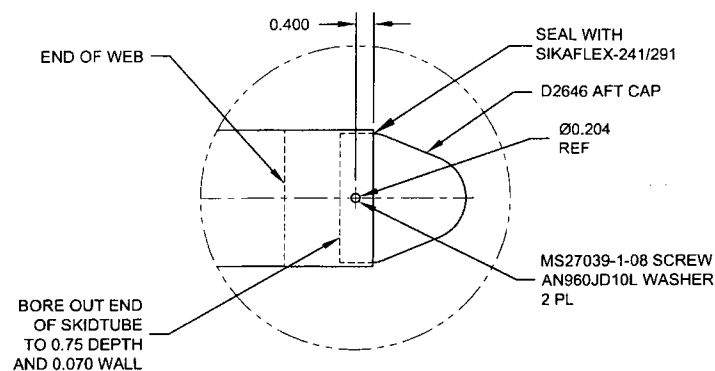
80062



VIEW G-G
SCALE NONE



DETAIL E
SCALE NONE



DETAIL F
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO. D3804	REV. A
MFG. APPR.	91	SHEET 5 OF 5	
APPROVED	91	SCALE	
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	
DATE	08.07.07	NTS	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 281

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 77988
Part number: A206-642-151
Description: SKID Tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 12.01.23
Welder Barclay Elliot Date of Test Coupon 12.01.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld